

Work Order ID 122787

July-25-14 9:53:36 AM

122787

Page 1

Item ID: D4974-1

Revision ID:

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00

Required Date: 7/25/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *MLJ*

QC:

Date: *14-07-25*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Accept ***N900040100***

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4974

D

105

0.00

105

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 12.875" LONG

110

0.00

110

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB230

DWG REV: *D*

FOLIO REV: *AA*

2- deburr and break all sharp edges

4

SL 14-7-25

4 *Ø*

DAS
20
9-89

14-07-26

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Item ID: D4974-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

4

Ø

DAS
20
9-89

14-07-26

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

S. = 14/07/27

4

Ø

DAS
08
9-89

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Outsource process - Anodize

Memo

Issue P/O to ATG : 25229

0.00

1- Black Anodize as per Dwg D4974

2- Prime as per dwg

Certification of Conformity is required

CL 14/07/30 (V)

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Item ID: D4974-1

Revision ID:

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00

Required Date: 7/25/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: CA	0.00							
180									
Packaging	Memo	0.00							
Packaging									

14/8/11 (4)

14/8/11

4X DAS 28 9-89 AUG 11 2014

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Page 4

Item ID: D4974-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 1408-12

MLJ 1408-12

Picklist Print

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Page 1

Work Order ID: 122787

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Parent Item: D4974-1

D4974-1

Parent Item Name: Upper Rail

Start Date: 7/25/14

Required Date: 7/25/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-11-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.750X02.25 0		Purchased			No		f	20.8170		5			

M7075T6B1 750X02 250

**

SL14-7-25

7075-T6 BAR 1.750" X 2.250"

Location

Loc Qty

Loc Code

MAT001

20.817

123418

0.5

M128502

8.317

M129237

12

*4.3

DART AEROSPACE LTD		Work Order: 122787
Description: UPPER RAIL		Part Number: 049741
Inspection Dwg: D4974 Rev: D		Page 1 of 1

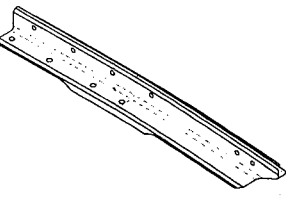
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.363	+/- .010	.3615	✓		SL08	Vern
.370	+/- .010	.365	✓			
1.260	+/- .005	1.260	✓			
1.811	+/- .005	1.811	✓			
2.095	+/- .005	2.094	✓			
1.378	+/- .005	1.376	✓			
Ø .201	+ .005 / - .001	.201	✓			
2.000	+/- .010	1.998	✓			
.830	+/- .010	.830	✓			
.991	+/- .010	.990	✓			
R.13	+/- .030	.125	✓			
.178	+/- .010	.177	✓			
.10 X 45°	+/- .030 X .5°	.100 X 45°	✓			
.340	+0.000 / - .004	.338	✓		SL02	Mic
1.000	+/- .010	.999	✓			
Ø .177	+ .005 / - .001	.178	✓			
Ø .166	+ .005 / - .001	.165	✓			
.277	+/- .010	.281	✓			
1.875	+/- .005	1.875	✓			
3.750	+/- .005	3.750	✓			
5.625	+/- .005	5.625	✓			
.750	+/- .005	.750	✓			

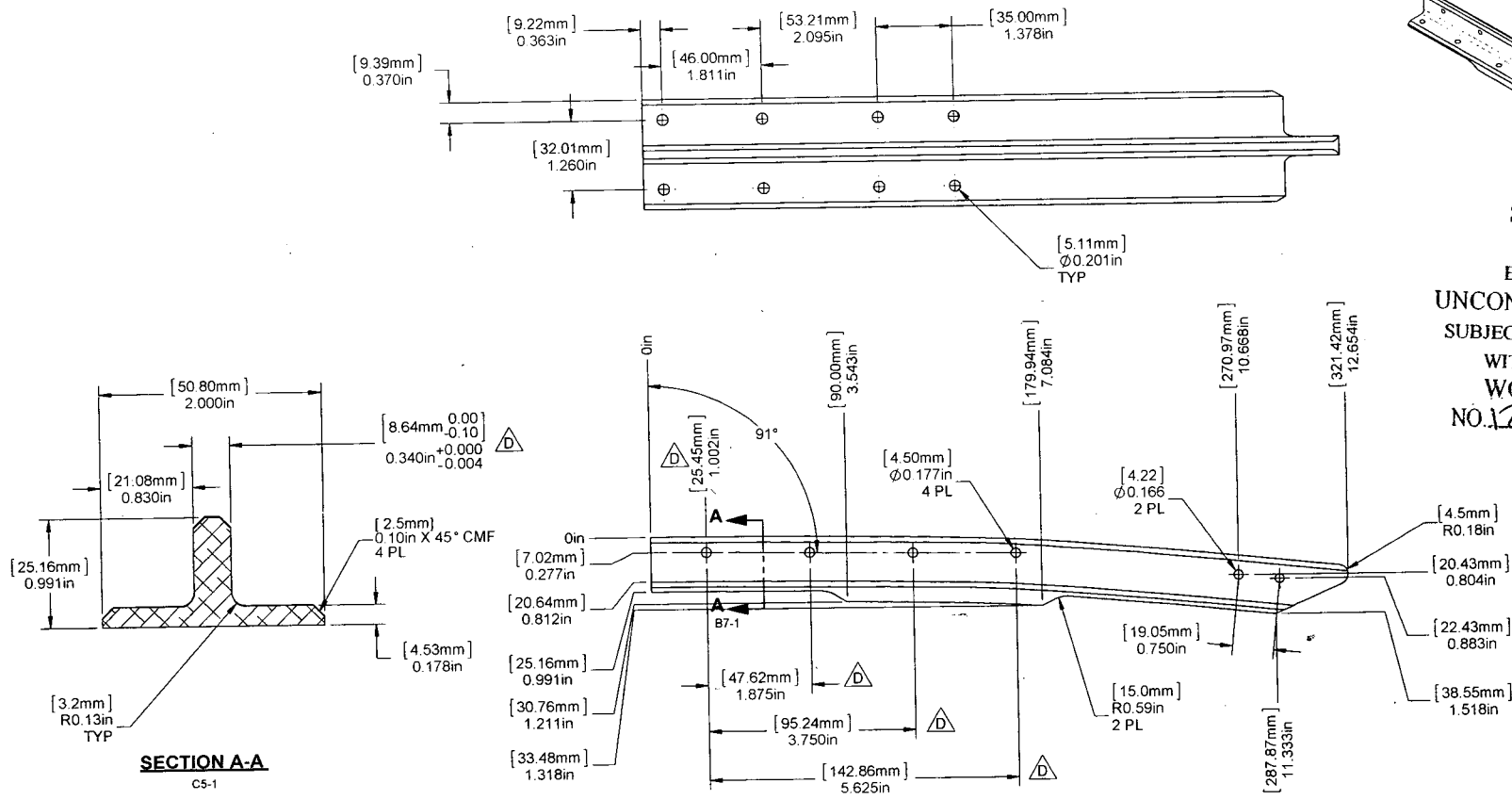
Measured by: 20 9-8	Audited by: DA Date: 14/07/21	DAS 08 9-89	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122787 MJS
1407-25



SECTION A-A
C5-1

D4974-1 UPPER RAIL

- NOTES:
- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
 - 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK.
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4974-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
 - 7) WEIGHT: 0.89 lbs (0.41 kgs)
 - 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4974-1-d.IGES

D	REVISED UPPER RAIL HOLE LOCATIONS (ZN B5-1). REVISED DIMENSION TOLERANCE (ZN C6-1)	AK	14.07.18
C	REVISE NOTE 6) (ZN A8-1)	AK	14.06.05
B	ADDED HOLES TO D4974-1 (ZN D4-1)	AK	14.05.07
A	NEW ISSUE	DC	13.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR	JFS	D4974	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR	DS	UPPER RAIL	NTS
DATE	14.07.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25229**

Purchase Order Date 7/30/14

PO Print Date 8/08/14

Page Number 3 of 8

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$3.60

6 122787 D4974-1 UPPER RAIL 8/15/14 4.00 \$16.00 \$64.00

Yes

8/15/14

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$64.00

7 122828 D4973-1 UPPER CUTTER DEFLECTOR 8/15/14 4.00 \$16.00 \$64.00

Yes

8/15/14

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$64.00

8 122765 D5140-1 UPPER CUTTER 8/15/14 4.00 \$16.00 \$64.00

Yes

8/15/14

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Note:

8/08/14



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63197

Date: 08-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
4 ea	Part: D4974-1 UPPER RAIL HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140485 PO: PO25229		
4 ea	Part: D4973-1 UPPER CUTTER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140486 PO: PO25229		
4 ea	Part: D5140-1 UPPER CUTTER HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140487 PO: PO25229		
4 ea	Part: DS140-2 UPPER CUTTER HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140488 PO: PO25229		
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63197

Date: 08-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	ATG SALES-2010 TERMS APPLY	
	DATE: <u>8/8/14</u>	
	CERTIFIED SIGNATURE: <u></u>	
	RECEIVER SIGNATURE: _____	